

Work Order ID 158813***158813***

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Friday, March 31, 2017 7:15:40 PM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 4/4/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 4/18/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED
Approvals: Process Plan: _____ Date: MAR 31 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3195	Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.11

Jeaspa Bandsaw

Cut blanks: (1.250" x 1.500") x 3.60" long

10 10 17/04/01
DAS 14 9-89

110

1.92

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

1.25

HAAS CNC vertical machine #1

1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-32-Deburr

10 10 17/04/02
DAS 14 9-89

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.05

Quality Control

10 10 17/04/02
DAS 14 9-89

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Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.10				<u>10</u>	<u>0</u>		<u>45</u> 9-89 174-3
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.48				<u>(10)</u>	<u>0</u>		<u>2017/04/07</u> BEB
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <u>M134858</u> Memo START TIME: <u>1:55</u> <u>3:00</u> FINISH TIME: <u>2:25</u>	0.00 0.39				<u>10</u>	<u>0</u>	<u>17-04-12</u>	<u>858</u>

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NS1

Stop *NS2*

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

**Insp.
Stamp**

160

OC

Memo

0.05

Quality Control

170

170

Small Fab

Small Fab

0.00

Memo

0.46

Small Fab

1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13 as per Dwg
D3195A/R Contact Cement 136812

D3195A/RContact Cement 136812
3M 1300L

180

180

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.10

Quality Control

10 FF APR 13 2017

10 Ø 17-4-13

DAS
19
9-89

10 38
9-89
APR 17 2017

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Item ID: D3195-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bracket
Start Date: 4/4/2017 Start Qty: 5.00 *5* Cust Item ID:
Required Date: 4/18/2017 Req'd Qty: 5.00 *5* Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>51021</u>	0.00							
190									
Packaging	Memo	0.05							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.50							
Quality Control									

10 DAS 6 9-89 APR 18 2017

17/4/19

APR 19 2017

Picklist Print

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Work Order ID: 158813

158813

Parent Item: D3195-043

D3195-043

Parent Item Name: Bracket

Start Date: 4/4/2017

Required Date: 4/18/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3195-7		Manufactured	No			100	Each	4.0000	1	5			DAS 19 9-99
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D3195-7

Pad

not pulled

159066

159572

158133

Location	Loc Qty	Loc Code
GA	4	
144098	1	
158133	3	

6

1

3

17-4-13

M6061T6B1.500X01.25
0

Purchased No

170 f 16.4000 0.3 1.578947

M6061T6B1 500X01 250

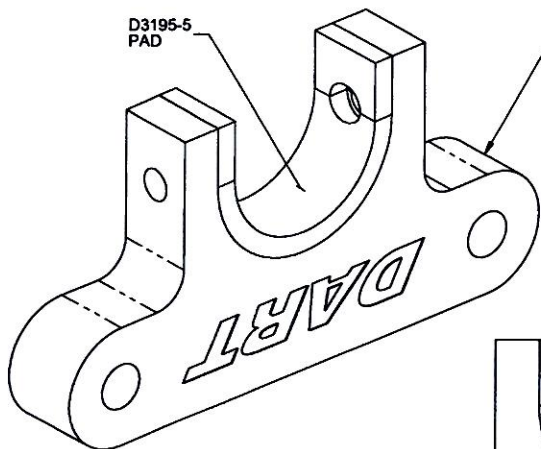
6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
MAT002	12	
m136882	12	
MAT003	4.4	
m135987	4.4	

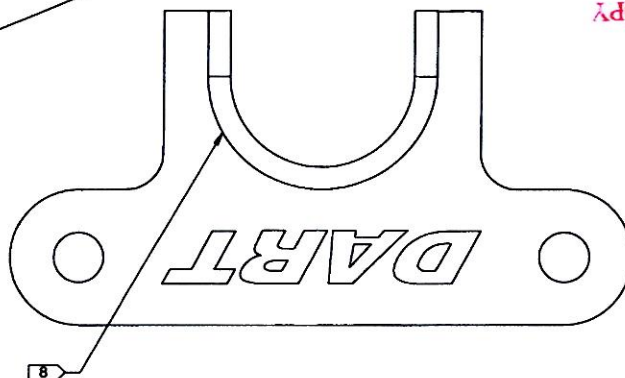
3.15

DAS
14
9-99

17/04/01



D3195-041 BRACKET



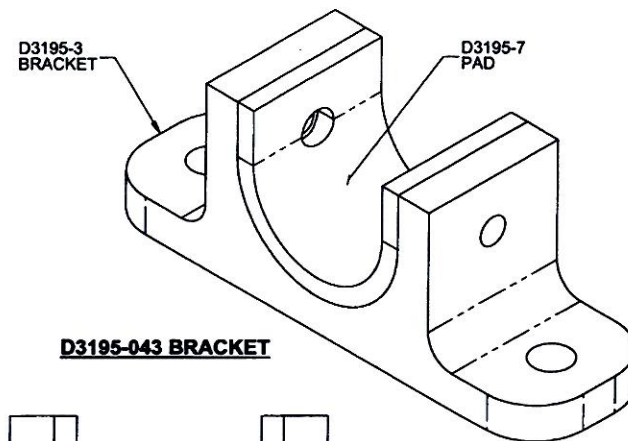
ITEM	QTY	P/N	DESCRIPTION
	X	D3195-041	BRACKET
1	1	D3195-1	BRACKET
2	1	D3195-5	PAD

NOTES:

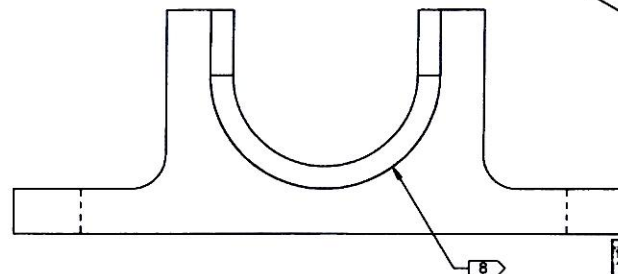
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3195-04X" AND BATCH NUMBER "BXXXXX" PER QSI044 METHOD 6.1
- 7) WEIGHT: D3195-041: 0.15 lbs
D3195-043: 0.14 lbs
- 8) BOND PAD TO BRACKET USING 3M SCOTCH-WELD HIGH PERFORMANCE 1300/1300L (OR EQUIVALENT)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 158813

07/03/10
 15/13/10



D3195-043 BRACKET



ITEM	QTY	P/N	DESCRIPTION
	X	D3195-043	BRACKET
1	1	D3195-3	BRACKET
2	1	D3195-7	PAD

RELEASED
 2012-04-30

B	- UPDATED DRAWING FORMAT. - ADDED NOTE 8, SHEET 1. - D3195-5 & D3195-7 DIMENSIONS EXTENSIVELY REVISED (B3-C3) - REF: PART11-130	RP	12.04.13
A	NEW ISSUE	CP	03.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3195 TITLE BRACKET COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	RP		
CHECKED	A.P.		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]	SCALE NTS	
DATE	12.04.13		

